

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020254**Date Inspected:** 04-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yu Dong Ping, Liu Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG/TOWER**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This Quality Assurance (QA) Inspector observed the following work in progress:

BAY 10

**TOWER FACADE SUBASSEMBLY**

SMAW welding of weld joint 002 located on SD1-SFSA4-1A/B.

Welder is identified as 052930. ZPMC QC is identified as Mr. Wang Hao.

The welding variables recorded by QC appeared to comply with WPS-B-P-2112-PADEYE.

FCAW welding of weld joint 005 located on BK004A1-028.

Welders are identified as 053869 & 57266. ZPMC QC is identified as Mr. Li Jun.

The welding variables recorded by QC appeared to comply with WPS-B-P-2232-Tc-U4c-F.

FCAW welding of weld joint 008 located on BK004A1-028.

Welders are identified as 057180 & 52075. ZPMC QC is identified as Mr. Li Jun.

The welding variables recorded by QC appeared to comply with WPS-B-P-2231-B-U2-F.

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FCAW welding of weld joint 047 located on BK004A8-028.

Welder is identified as 057180. ZPMC QC is identified as Mr. Li Jun.

The welding variables recorded by QC appeared to comply with WPS-B-P-2133.

## BAY 11, OBG BIKE PATH

During random in process inspection this QA inspector observed that ZPMC personnel performing buttering on the edge of stringer plate(8A) of bike path by using Flux Cored Arc Welding (FCAW) process. Welder is identified as 049220. ZPMC QC is identified as Mr. Mao Bin Bin. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-G(1F)-REPAIR-1.

FCAW welding of weld joint 008 located on BK005B1-004.

Welder is identified as 054460. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-P-2231-B-U2-F.

FCAW welding of weld joint 066 located on BK005B4-004.

Welders are identified as 040723 & 054460. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-P-2132.

SMAW welding of weld joint 039 located on BK004A6-017.

Welder is identified as 044541. ZPMC QC is identified as Mr. Shao Hai Lang.

The welding variables recorded by QC appeared to comply with WPS-B-P-2113.

FCAW welding of weld joint 051 located on BK004A3-022.

Welder is identified as 067138. ZPMC QC is identified as Mr. Shao Hai Lang.

The welding variables recorded by QC appeared to comply with WPS-B-P-2132.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Gaikwad,Umesh
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Carreon,Albert
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QA Reviewer
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